

Date:
User:Friday, 7/20/2007 10:21:38 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STRUT WELDMENT ASSY

Job Number : 33698

Estimate Number : 10675

P.O. Number : N/A

This Issue : 7/20/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : LARGE FAB ASSY

Previous Run : 33477

Part Number : D3443041

Drawing Number : D3443 REV. B

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 8/2/2007

Qty: 5 Unit: Each

Written By : HA 07.07.20Checked & Approved By : HA 07.07.20

Comment : EST REV. A 05.11.17 NEW ISSUE EC

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

D34431

Lug

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3443-1

lug

B33707 → 2

PD 07-10-12 ②

2.0

D34435

Tubing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3443-5

Tubing

B33616 → 2

PD 07-10-12 ②

3.0

D34531

Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-1

Clevis

B34942 → 2

PD 07-10-12 ②

4.0

238805

SS DOWEL PIN 3/4" LONG

Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

238-805

SS DOWEL PIN 3/4" LONG

M105037 → 2

M19080 → 2

PD 07-10-12 ②

Date: Friday, 7/20/2007 10:21:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33698

Part Number: D3443041

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3443

PD 07-10-12 (2)

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MA 07/10/12 (2)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 07/10/15 (2)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
1-Mask holes as per dwg D3443

M 105 068

(2X)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

MA 07/10/15

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 07-10-15

(2)

10.0 63215K32 Spherical Bearing



Comment: Qty: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	63215K32	Spherical Bearing	

Batch

MA 1103199

MA 07/10/15 (2)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

MA 07-10-15 (2)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 07/10/15 (2)

Date: Friday, 7/20/2007 10:21:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33698

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13 0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GPA

MF 07-10-15

14 0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

②
H 07/10/16

Job Completion



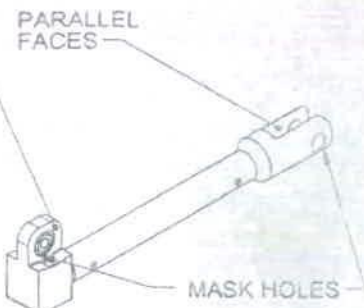
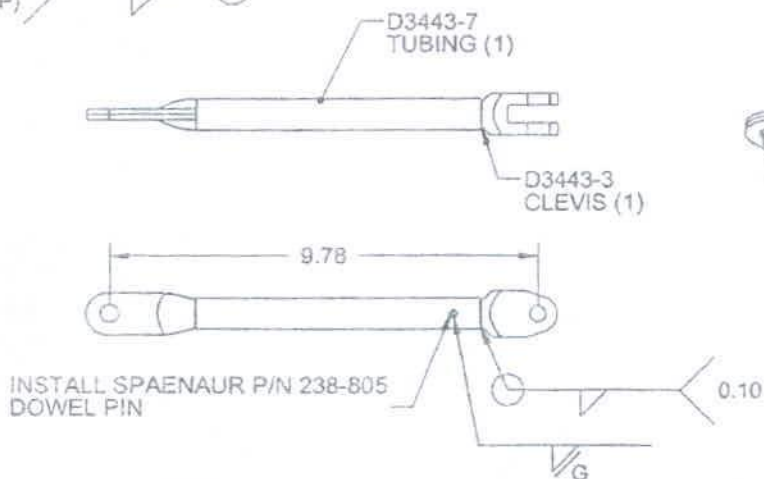
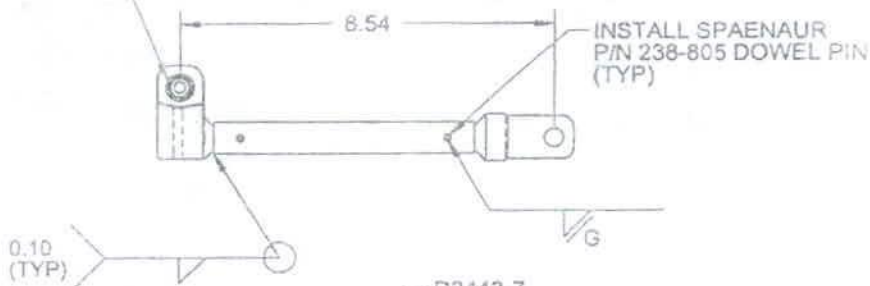
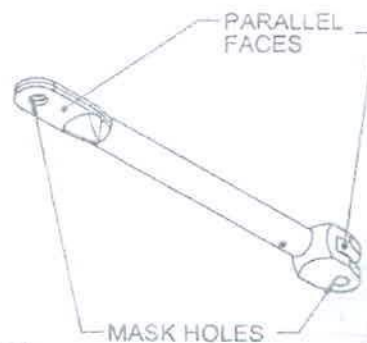
U 07/10/16

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER, REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
NO 33698



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\varnothing 0.210^{+0.005}_{-0.010}$



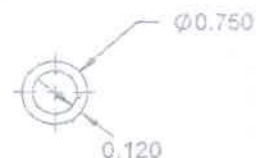
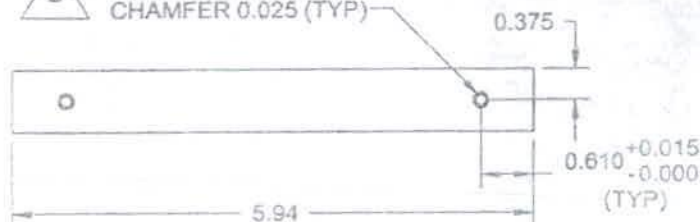
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025 (TYP)

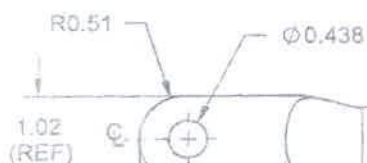
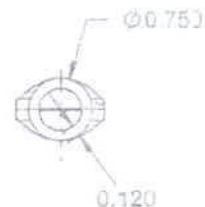
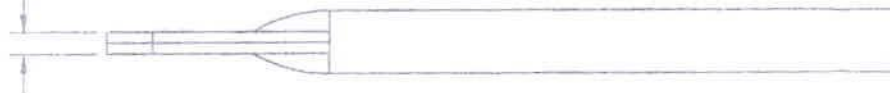


RELEASED

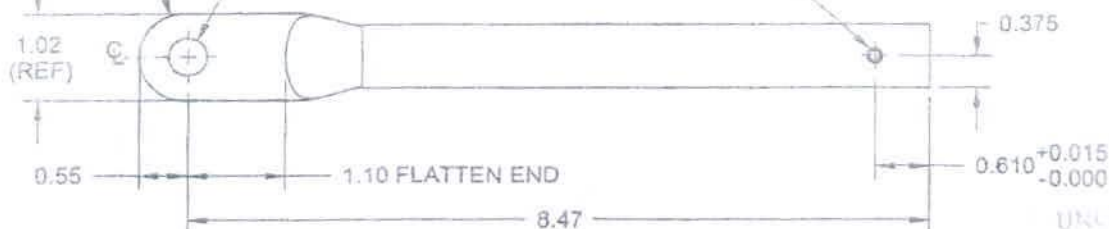
05.12.05

D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

